

Work Order ID 112215

July-10-14 10:41:54 AM

112215

Page 1

Item ID: 647.0112

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Bracket

Start Date: 1/30/14

Start Qty: 95.00

95

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 95.00

95

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 14-07-10

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.0100

A

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: Q

2-Deburr if necessary

100

mm 14/07/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

Quality Control

100

mm 14/07/17

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Page 2

Item ID: 647.0112

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Strut Bracket

Stop

NS2

Start Date: 1/30/14

Start Qty: 95.00

95

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 95.00

95

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-13

0.00

14/11/17

100
Cem

120

QC

Memo

Quality Control

130

Form as per dwg

0.01

NC BRAKE

130

Brake NC

Memo

0.16

Brake NC

USE DT9834 FOR FORMING

100x

DL 14-8-14

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
16
9-89

DAS
38
9-89

14/08/18

14/08/15

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Page 3

Item ID: 647.0112

Accept

N900040100

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Revision ID:

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Start Date: 1/30/14

Start Qty: 95.00

95

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 95.00

95

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

SprayPaint

Memo

0.00

Spray Painting

PRIME AS PER DWG NOTE 6

BATCH: 128987

DAS
41
9-89

14-8-20

160

0.00

160

QC

Memo

0.00

Quality Control

QC14- Inspect Spray Paint

DAS
38
9-89

100

2

20

14/08/22

170

0.00

170

Packaging

Memo

0.00

Packaging

Identify as per dwg & Stock Location: CK 106

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

100 x

SP

14-8-22

Work Order ID 112215

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112215

Page 4

Item ID: 647.0112

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Bracket

Start Date: 1/30/14 Start Qty: 95.00

95

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 95.00

95

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 14-08-22

APY-8.22

Picklist Print

July-10-14 10:41:57 AM

Page 1

Work Order ID: 112215

112215

Parent Item: 647.0112

647 0112

Parent Item Name: Strut Bracket

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 95.00

Required Qty: 95.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	75.2500	0.0325	4			

M304S14GA

304SS sheet .080

mm 14/07/17

Location

Loc Qty

Loc Code

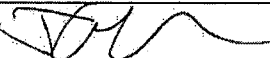
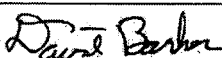
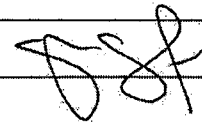
MAT020

75.25

M126075

75.25

4.6

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: SHEET METAL				
	APPROVED BY: ENGR. 	MFG. 	QC. 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

IS

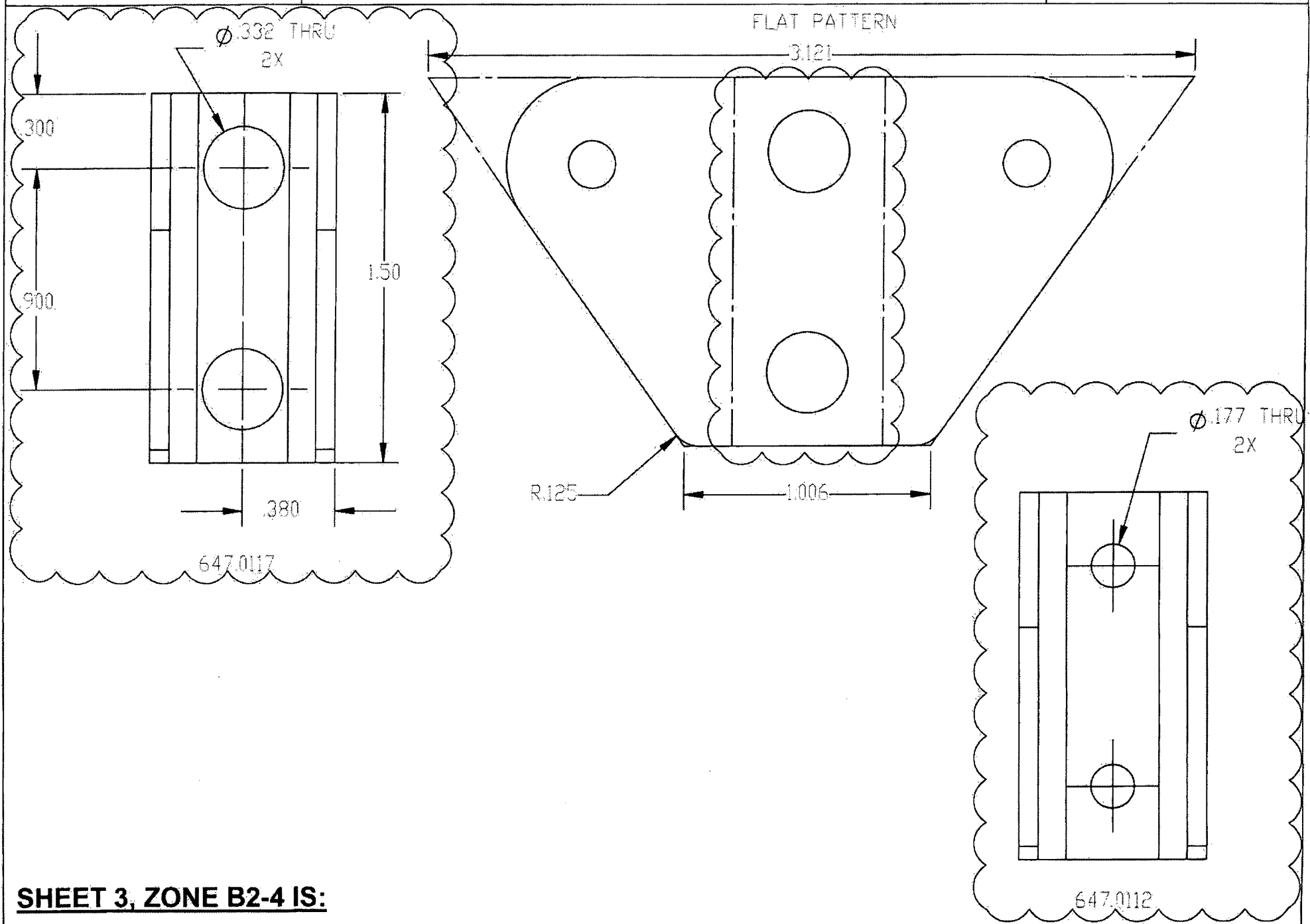
NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
- 3. DEBURR AND BREAK ALL SHARP EDGES.
- 4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

112215 MWS
14-01-31

SHEET 1, ZONE D1 IS:

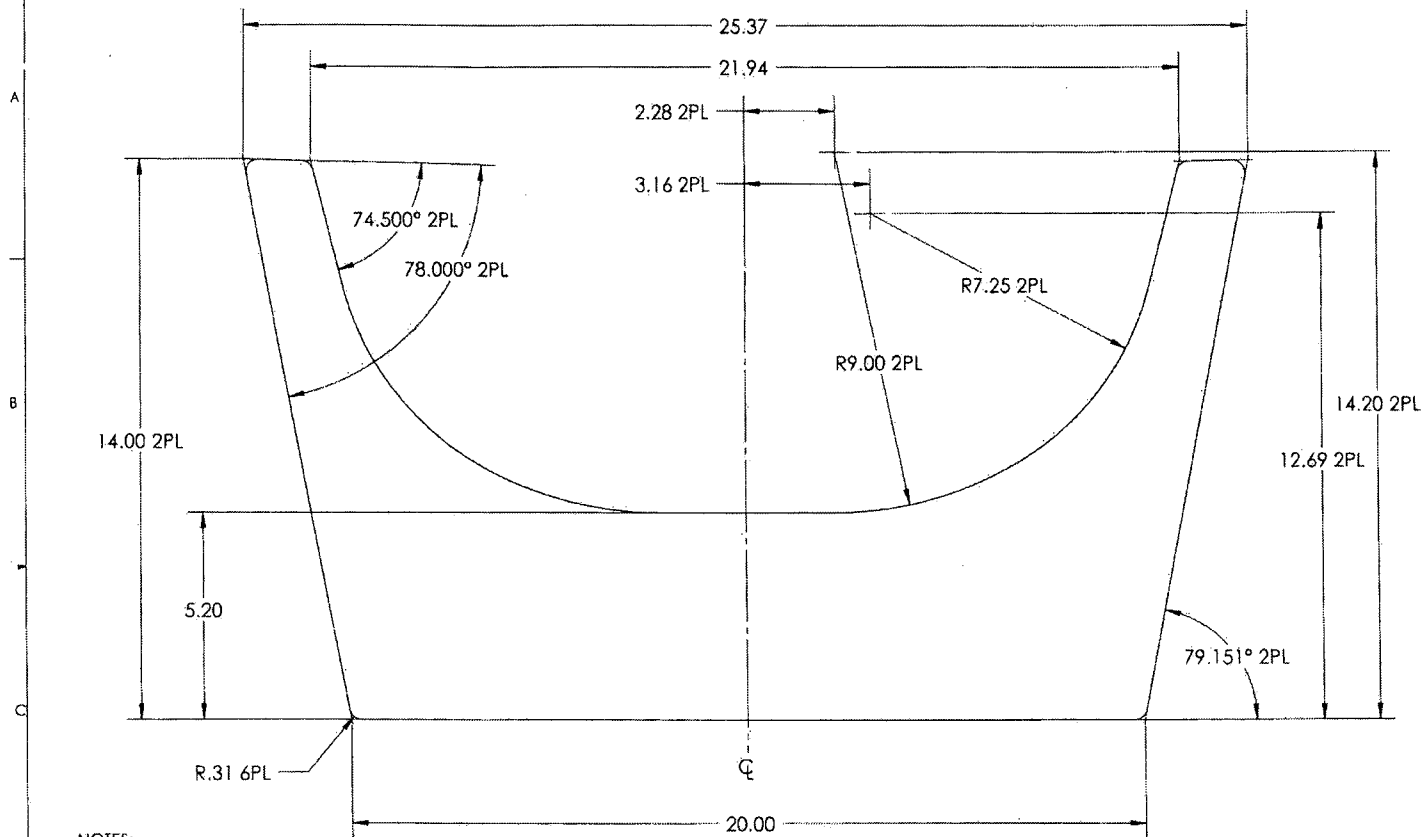
C	647.0117		STRUT BRACKET	△	△
F/N TC	PART NUMBER		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIRED	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input type="checkbox"/> BOM			<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	



SHEET 3, ZONE B2-4 IS:

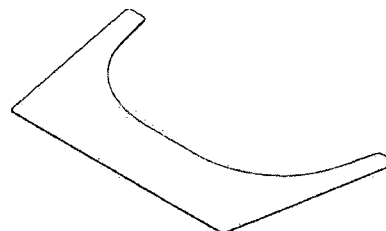
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION 100		
2	INITIAL RELEASE	03/28/09	P. BRAYO
3	INCORPORATED ECN 02725, 02944, 03081	04/22/11	P. BRAYO



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



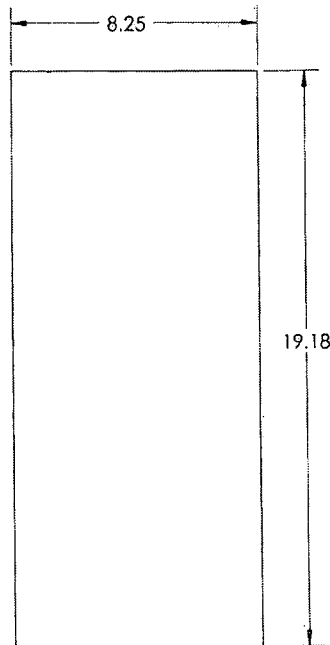
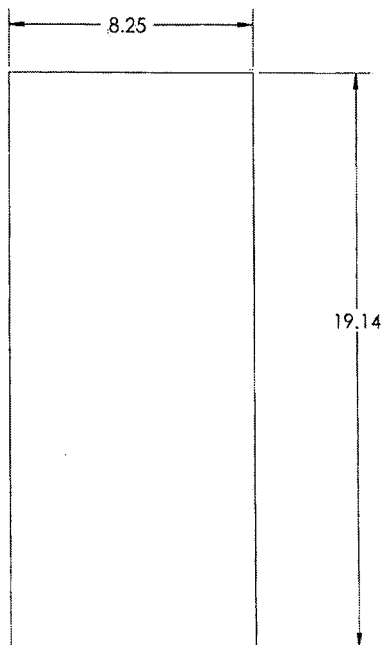
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UNINCORPORATED ECN(S)

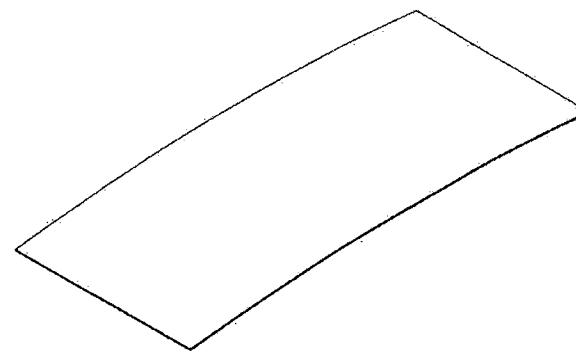
03.985

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
NEXT ASSY (S)			PARTS LIST		
646.9500			APICAL INDUSTRIES		
			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHEETMETAL		
			SHEET	647.0100	REV A
			SCALE NONE	SHEET 1 OF 6	

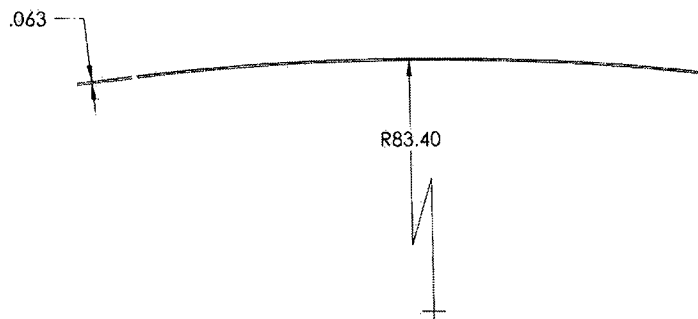
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FLAT PATTERN



647.0111



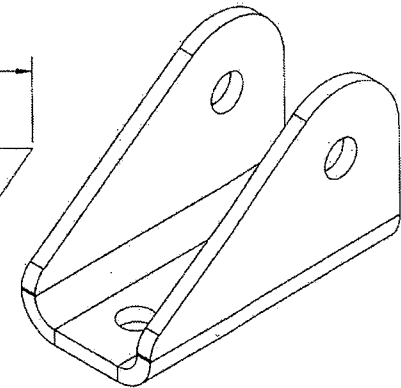
ORIGINAL DATE: 05-28-08		APICAL INDUSTRIES	
DRAWN BY: R. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAYO		SHEETMETAL	
CONTRACT NO.		DWG. NO. 647.0100	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SIZE: CAGA-CODE: 8	REV. A
SCALE: NONE		SHEET 2 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

Ø.177 THRU
2X

FLAT PATTERN



647.0112

R.125

1.006

Ø.191 THRU
2X

R.125
2X

.650
2X

.350
2X

.080 TYP

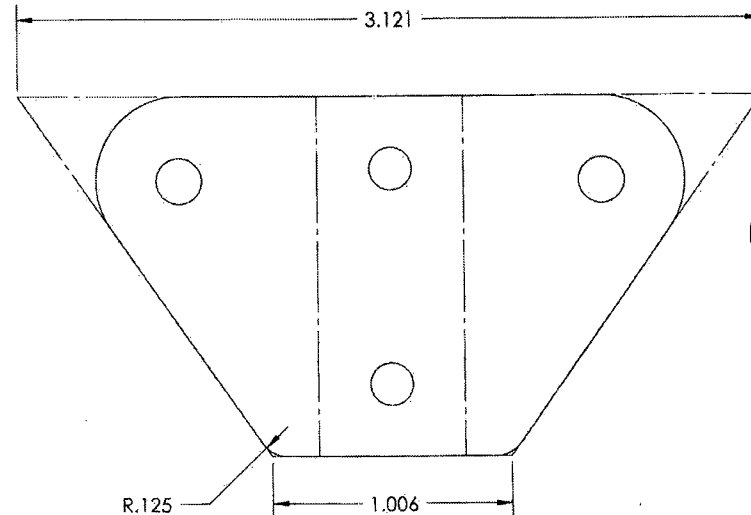
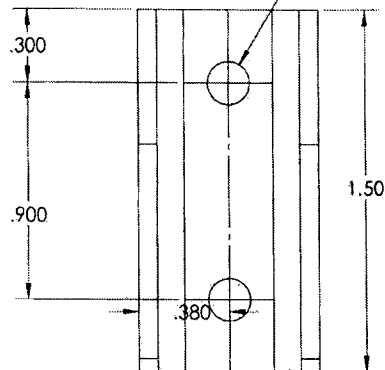
R.193
2X

R.188
2X

1.00
305

.375

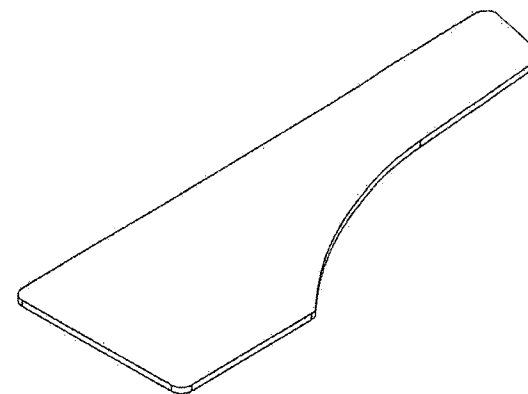
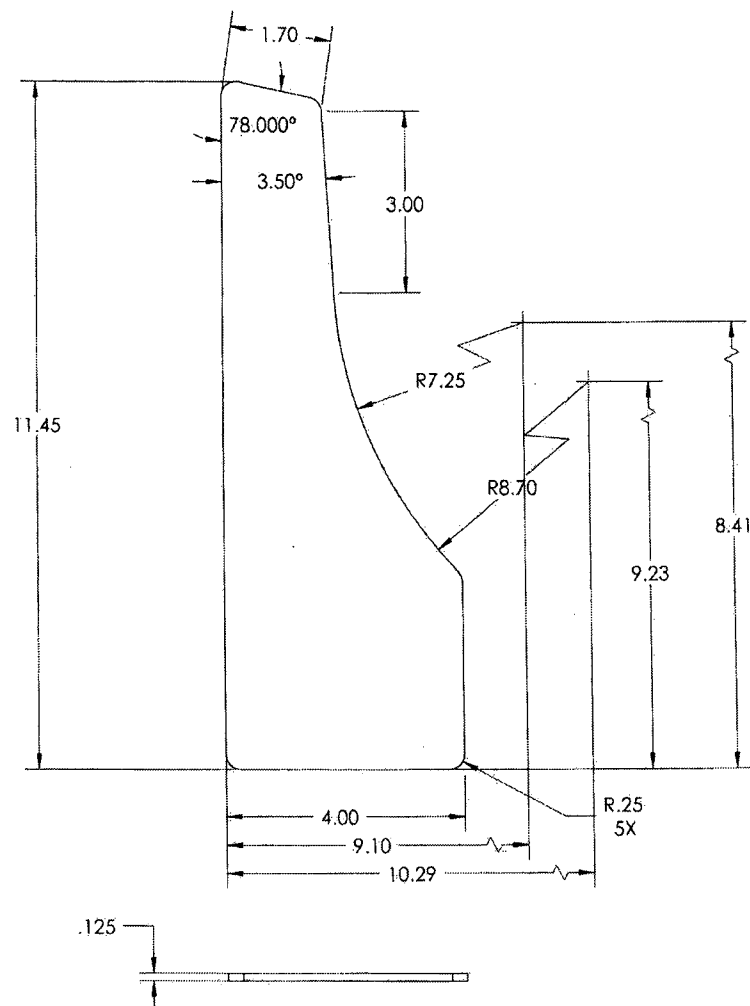
.603



ORIGINAL DATE 05/28/00 DRAWN BY P. ROSARIO CHECKED BY P. ROSARIO DRAWING APPROVAL BY BRAND DATE 06/28/00 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.0°	SHEET 3 OF 6
SCALE NONE	REV. A

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

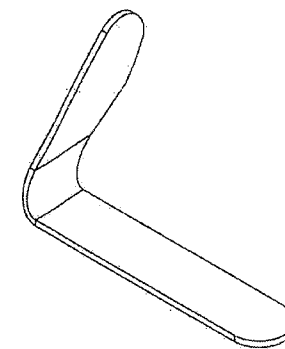
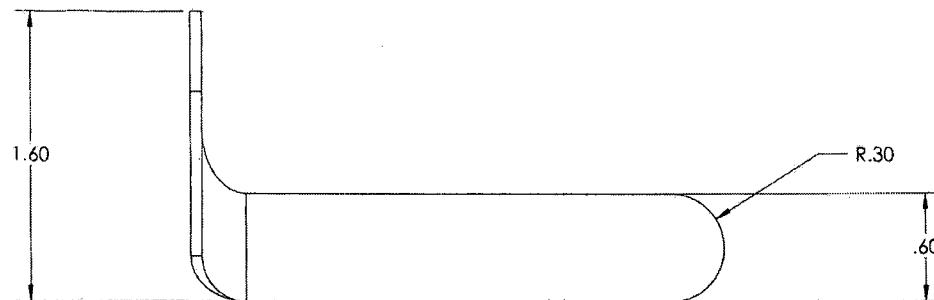


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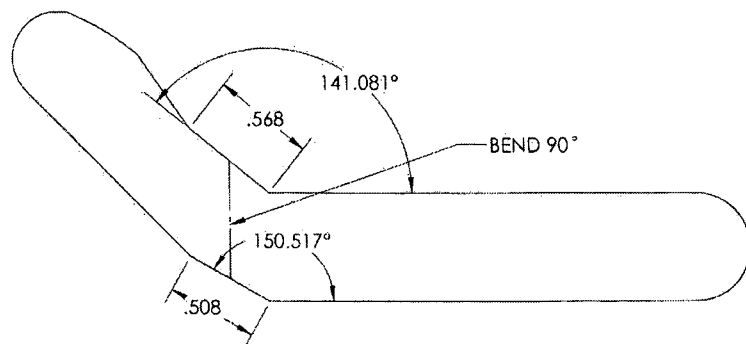
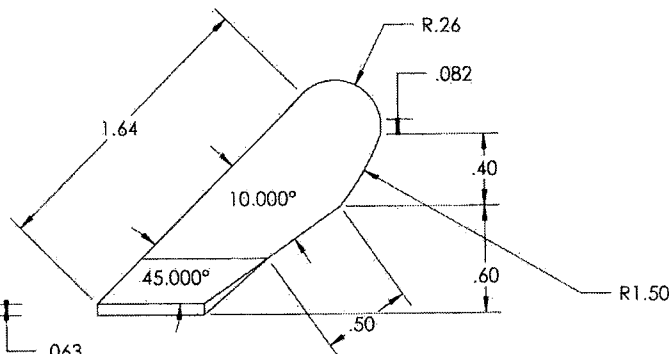
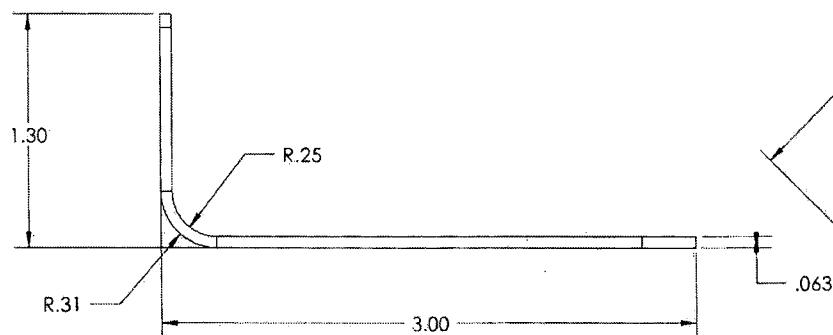
ORIGINAL DATE: 05-28-09		APICAL INDUSTRIES	
DRAWN BY: J. KEDIANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL:		SHEETMETAL	
BY: J. BRAVO			
DATE: 05-28-09			
CONTRACT NO.:			
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
SHEET: B	CAGE CODE: 07M26	DWG. NO: 647.010J	REV: A
SCALE: NONE		SHEET: 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

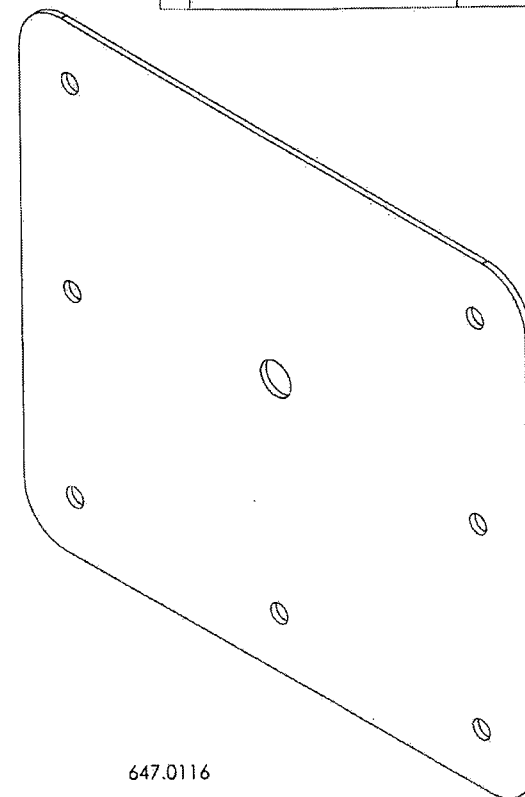
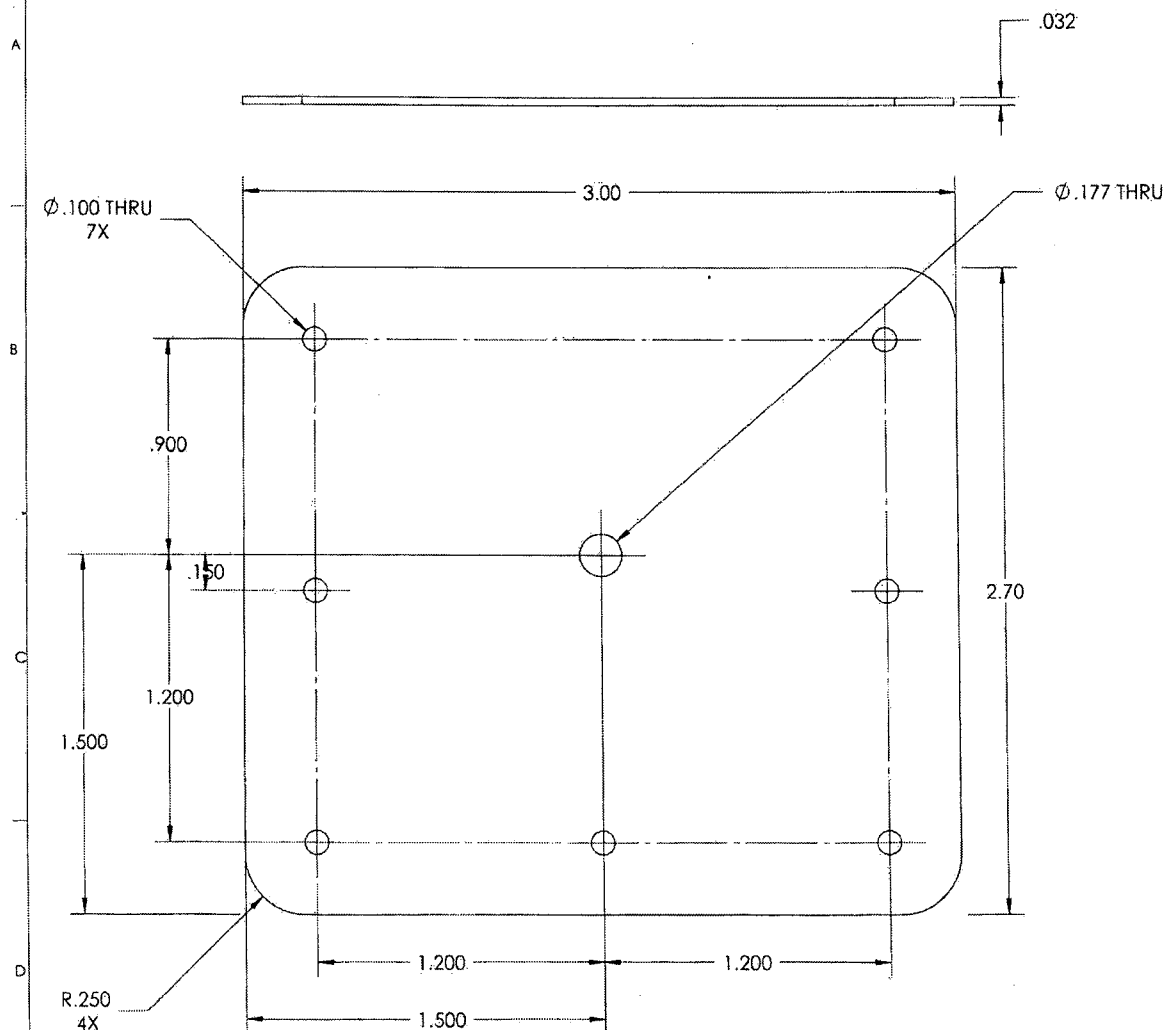


FLAT PATTERN

ORIGINAL DATE INCHES - 1/8 05-28-09		APICAL INDUSTRIES	
DRAWN BY R. POLANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
CONTRACT NO.		DWG. NO. 647.0100	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: ± .01 3 PLACE DECIMALS: ± .005 ANGLES: ± .5°		SCALE: NONE	REV. A
		SHEET 5 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE 10-01-1971 08:18:00		APICAL INDUSTRIES	
DRAWN BY P. ROTANDO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
DATE 10-28-71		SCALE NONE	
CONTRACT NO.		SHEET 6 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET CODE B 07M26	REV A
DWG. NO. 647.0100		SCALE NONE	